

S-10018.D2

Type : Basic

Conformances

AWS A5.5/ ASME SFA5.5 E10018-D2 H4R

ABS AWS A5.5 E10018-D2 H4R

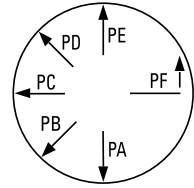
Applications

- Carbon-Manganese and Chromium-Molybdenum steel Pipng (AISI 4130, 4140)

Features

- Low hydrogen electrode
- Welding 690MPa class Low alloy steel

Welding Position



Current

AC or DC +

Redrying Conditions

350~400°C (662~752°F) X

0.5~1hr

Diameter / Packaging

Diameter	Length	Standard		Vacuum	
		packet	carton	packet	carton
mm (in)	mm (in)	5kg(11lbs)	20kg(44lbs)	5kg(11lbs)	20kg(44lbs)
3.2 (1/8)	350 (14)	✓		✓	
4.0 (5/32)	400 (16)	✓		✓	
5.0 (3/16)	400 (16)	✓		✓	

SWAW

SAW

GMWAW

GTAW

FCWAW

Non-FERROUS

APPENDIX

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni	Mo
0.08	0.35	1.075	0.015	0.005	0.78	0.29

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN Impact Test J J (ft.-lbs)	Heat Treatment
625 (90,700)	705 (102,300)	26	-50 (-58)	45 (33)	620°C(1148°F) X 1hr

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	350 (14)	400 (16)	400 (16)
F &HF	90~130	130~180	180~240
V-up, OH	85~120	110~170	-